

Work Order ID 58216

Thursday, April 29, 2010 10:38:40 AM



Page 1

Item ID:	D3407-5	Accept		Setup	Start	
Revision ID:						
Item Name:	Ring				Stop	
Start Date:	4/29/2010	Start Qty: 12.00		Cust Item ID:		
Required Date:	5/14/2010	Req'd Qty: 12.00		Customer:		
Reference:						

Approvals:	Process Plan: <u>UMF</u>	Date: <u>10-4-29</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3407	Rev E								

100
 FLOW WATER JET 0.00
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3407 ☐ Dwg Rev: E ☐ Prog Rev: E ☐ 2-
 Break edges on grinder as per Dwg D3407
17-4 250 X 4

110
 QC2- Inspect parts off machine FAI/FAIB 0.00
 QC Memo 0.00
 Quality Control

120
 QC8- Inspect parts - second check 0.00
 QC Memo 0.00
 Quality Control

RB 10-5-3

EP 10/05/04 (20)

RB 10-5-3

Diols/04

count
(+20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3407-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Ring

Start Date: 4/29/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *Erich*

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-5-5 *sf* *(20)**10/05/05* *[Signature]**CL10/5/14*

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Picklist Print

Thursday, April 29, 2010 10:38:39 AM

Page 1

Work Order ID: 58216



Parent Item: D3407-5



Parent Item Name: Ring

Start Date: 4/29/2010

Required Date: 5/14/2010

Comments: IPP Rev:A New Issue 05-11-22 JLM
 IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD
 IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
M174B0.250X4.000		Purchased	No			100	f	12.8000	0.2666	5.5		
											10-5-3	
17-4 SS Bar .250 X 4.00												

Location

Loc Qty

Loc Code

MAT

12.8

114415

12.8

114415

20

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Dart Aerospace Ltd

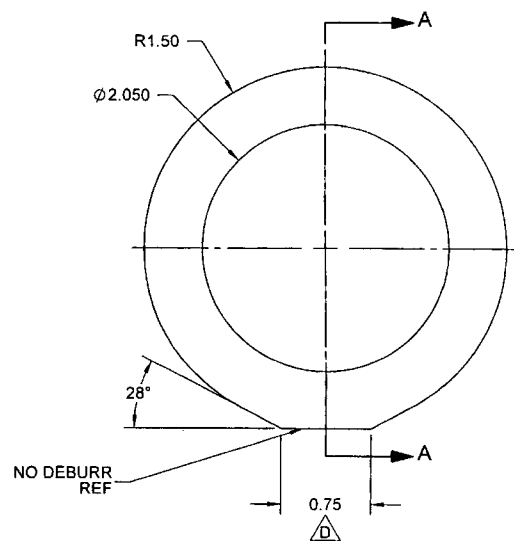
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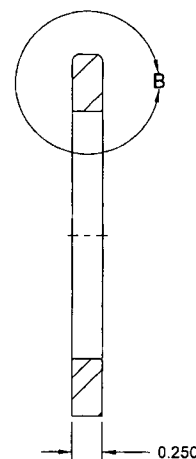
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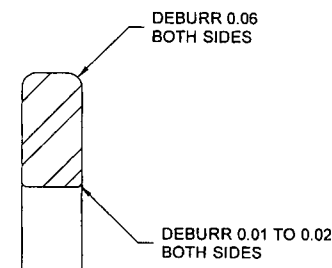
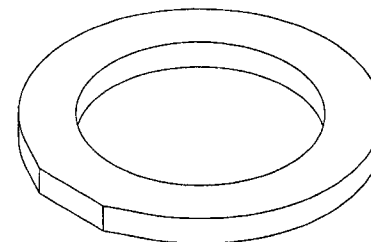


D3407-5 RING

#58016



SECTION A-A



**DETAIL B
SCALE 2X**

RELEASED
08-08-01/10

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

DESIGN	90	DART AEROSPACE USA, INC.	
DRAWN	1/11	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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